

Repeat



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D205-596-103B
Job Sheet 182671

**Part No:** D205-596-103B**Job Qty:** 1 ea**Part Name:** Aft Crosstube - Extended Height 39"**Part Weight:** 0 lbs**Status:** Scheduled**Priority:** Medium**Job Created:** 8/29/18**Job Tracking No:****Due Date:** 9/27/18**Created By:** Marie Lajeunesse**Type:** SOLD**Description:**

Note: DWG REV C IPP REV:A 13.11.29 as per dwg DEO B-2 DD VERF:JLM IPP REV:B 14.02.12 AS PER DSI9684
REVA DD VERF:JLM IPP REV:C 15.01.28 as per dwg DEO B-3/CHG004DD VERF:JLM IPP REV:D 18/08/30
AS PER DWG REV.C JFS VERIFIED BY:DD

Ship Via:**Bill of Materials**

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S108200**Part:** D205-596-103B**Job No:** 182671**Serial No/Batch:** S108200**Revision:** C**Inspector:****Exp Date:****Instructions:** TC STC SH03-6 Issue 4, FAA STC SR01742NY 13/11/04, EASA STC

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	9/27/18	9/27/18	0.00	0.00	Start Up Crosstubes-1		GP 2018-09-05
105	HandFXtube	1 pcs	9/27/18	9/27/18	0.00	1.71	Crosstubes-3		D.R 18/09/05
107	QC	1 pcs	9/27/18	9/27/18	0.00	0.00	QC7-1		GP 2018-09-11
110	CNC Bend Crosstubes	1 pcs	9/27/18	9/27/18	0.00	3.84	CNC Bend Crosstube		GP 2018-09-11
120	Crosstubes	1 pcs	9/27/18	9/27/18	0.00	1.13	Crosstubes-1		GP 2018-09-11
130	QC	1 pcs	9/27/18	9/27/18	0.00	0.00	QC15		38
140	Crosstubes	1 pcs	9/27/18	9/27/18	0.00	1.13	Crosstubes-1		GP 2018-09-11
150	HandFXtube	1 pcs	9/27/18	9/27/18	0.00	1.71	Crosstubes-3		GP 2018-09-11
160	QC	1 pcs	9/27/18	9/27/18	0.00	0.00	QC7-1		38 DAS
170	QC	1 pcs	9/27/18	9/27/18	0.00	0.00	QC5		9-89 38
180	SprayPaint	1 pcs	9/27/18	9/27/18	0.00	1.97	Spray Paint		SEP 27 2018
190	QC	1 pcs	9/27/18	9/27/18	0.00	0.00	QC14		38
200	Crosstubes	1 pcs	9/27/18	9/27/18	0.00	1.13	Crosstubes-1		SEP 27 2018
210	QC	1 pcs	9/27/18	9/27/18	0.00	0.00	QC5		OCT 01 2018
215	DC	1 pcs	9/27/18	9/27/18	0.00	0.00	DC		9-89
220	Packaging	1 pcs	9/27/18	9/27/18	0.00	0.00	Packaging3-1		DAS 38
230	QC21-FG	1 Ea	9/27/18	9/27/18	0.00	0.00	QC21		21 38

Part Op 105 - INSIDE AND OUT

Descriptions: 110 - Bend as per dwg D2890 using CNC bender program

120 - 1-Mark 37.30" for cutting from tangential line in the straight section from D2890 as per Dwg wall template.

140 - 1-Cut as per Dwg D205-596-103 2-Deburr & Inspect for surface damage. Polish cut surface. Scribe part # and batch # on one end of tube.

150 - ***IMMEDIATELY AFTER GRINDING*** 1- PRESSURE WASH X-TUBE INSIDE AND OUT 2- ALODINE AND ACID ETCH X-TUBE INSIDE AND OUT AS PER QSI005.

180 - 1-Prime inside and outside per QSI 005 4.2 PRIMER BATCH: 138577 2- Paint outside as per dwg QSI 005 4.2 PAINT BATCH: 138949

200 - ****Ensure to scuff and install per DEO D205-596-103B**** 1- Lightly scuff the bonded area using a 180 grit sand paper and clean the area with 41058 wash 'n' wipe 2- Apply Proseal as per dwg D205-596-103 (DEO). A/R Proseal 890 B-2 Batch: 5096394 EXP: 3/19 3- Torque clamps 80 to 100 in-lb as per dwg and Note 11 (DEO B-2)

210 - ***PRIOR TO PACKAGING RECHECK TORQUE ON CLAMPS AFTER PROSEAL HAS CURED 72HOURS.***

215 - Photocopy D205-594 bluefile & type labels per PPP D205-596-103 CHG004

220 - Identify and pack for shipping as per PPP D205-596-103 Location: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6008-180	Crosstube Extrusion 153572	1 Ea (1 ea)	90-Start up Operation	
D3595-063-530	Rubber Cushion 0.63" Wide X 5.30" Long	4 Ea (4 ea)	200-Crosstubes	
D5018-1	Support, 214 Aft	2 Ea (2 ea)	200-Crosstubes	
MS21920-28	Clamp	4 Ea (4 ea)	200-Crosstubes	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6008-180	1	8	0
200-Crosstubes	D3595-063-530 5080001	④	13	0
	D5018-1 F130679	②	10	0
	MS21920-28 5083556	④	96	0

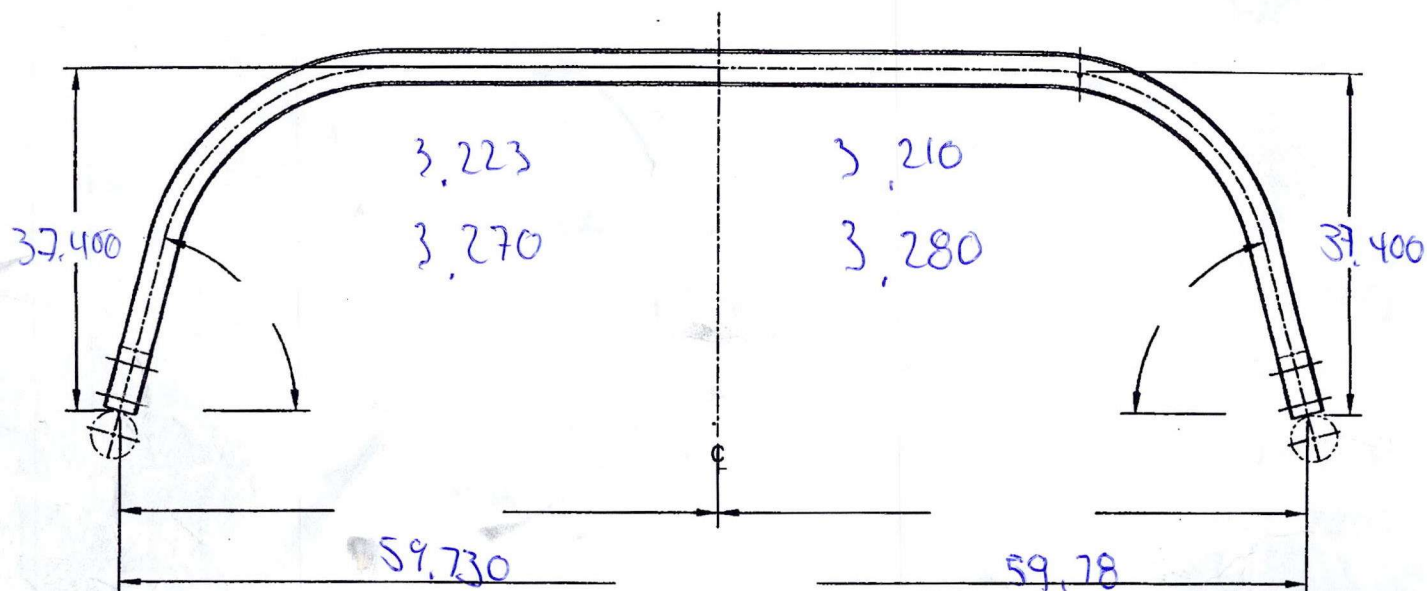
Part Specifications

Specifications could not be found.

Plex 9/5/18 11:45 AM dart.white.jesse

DART AEROSPACE LTD		Work Order:	
Description: Crosstube High-High Aft		Part Number:	D205-596-103
Inspection Dwg: D205-596-103	Rev: B <i>C</i>		Page 1 of 1

Required Dimension	Min	Max
Height	37.2	37.4
1/2 Span	58.7	58.9
Angle	49	52
Total Span	117.4	117.8
Bending Passes	3	--
Crushing	--	6%



	Side A	Side B
Bending Passes		
Crushing	0.7%	1%
Comments		

QC15 Inspection	<i>EB</i>
Date	18-09-10

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	08.04.21	Dwg Rev updated	KJ/JM	
C	12.04.16	Added bending, crushing dimensions	KJ	<i>JP</i>

PARTS LIST:

ITEM	QTY -103	QTY -103B	PART NUMBER	DESCRIPTION
	X		D205-596-103	CROSSTUBE ASSEMBLY, HI-HI AFT
		X	D205-596-103B	CROSSTUBE ASSEMBLY, HI-HI AFT, 214
1	1	1	D6008-180	CROSSTUBE
2	2		D2940-1	SUPPORT
3	4	4	D3595-063-530	RUBBER CUSHION
4		2	D5018-1	SUPPORT, 214 AFT
5	4	4	MS21920-28	CLAMP
6	A/R	A/R	PROSEAL 890 B-2	SEALANT (OR AMS-S-8802 CLASS B-2)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURE FROM D6008-180
FINISHED LENGTH = 146.98 ± 0.02
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS
- 7) WEIGHT: 55 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE
- 9) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) TO INSTALL D2940-1 / D5018-1 SUPPORTS: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 12) INSTALL MS21920-28 CLAMPS WITH D3595-063-530 RUBBER CUSHIONS TO SECURE D2940-1 / D5018-1 SUPPORT. ENSURE CLAMP MECHANISMS ARE ON TOP SIDE OF CROSSTUBE.
NOTE: IT IS ACCEPTABLE TO SUBSTITUTE MS21920-28 CLAMPS WITH LONGER OR SHORTER MS21920-XX CLAMPS TO ACCOMMODATE VARYING DIAMETERS. ENSURE THERE IS A MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

RELEASED

2018 JAN 24
ECN 18-525

C	REFORMAT, ADD SHT 3, HEIGHT/WIDTH TOL IS. ±0.13 WAS ±0.1, ADD TOTAL WIDTH DIM (B4-2, B4-3), CLAMP ORIENTATION FLIPPED (A5-2, A5-3), INCORP ALL DEO'S	CP	17.08.23
B	SUPPORT NOW MAGNOBONDED; REMOVE D2856-800-1009 ABRASION STRIP; UPDATED NOTES; ADDED D3595-063-530 CUSHION	MB	07.12.03
A	NEW ISSUE	DS	02.05.27
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED	AJS		
MFG. APPR.	IS		
APPROVED	WM		
DE APPR.			
DATE	17.08.23		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D205-596-103	REV. C SHEET 1 OF 3
TITLE CROSSTUBE ASSEMBLY, HI-HI AFT	SCALE NTS
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